

Date: Thursday, 2/14/2008 2:20:57 PM
 User: Kim Johnston

Process Sheet

9

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 GHW ADAPTER
 Job Number : 37451
 Estimate Number : 10571
 P.O. Number :
 This Issue : 2/14/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D206651041
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D206-651 REV. B
 Previous Run : 34773 Project Number : N/A
 Material :
 Due Date : 2/28/2008 Qty: 30 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: F 02.08.14 Re-format KJ
 Est Rev: G Removed Purchasing 07-03-21 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-651-041 CHG001

(30)

KS 08.02.19

2.0 D2692 Spring Pin Clip



Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2692 Spring pin

B36682

SP

3.0 D2711 Lock Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2711 Pin

B34792 (3X)

* B37461 (27X)

SD

4.0 AN960JD10 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 AN960JD10 Washer

M106852

8/3/19 SD

(30X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206 GHW ADAPTER

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

CBL1240

Cable



Comment: Qty.: 1.7500 f(s)/Unit Total : 52.5000 f(s)

Pick:

Qty Part Number

Description

Batch

21" CBL-1240

Cable

~~M107234~~

M103927

50

6.0

CBL460

Loop Sleeve



Comment: Qty.: 4.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 CBL-460

Loop sleeve

~~M107234~~

50

7.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 MS21042L3

Nut

~~M106242~~

(35x)

M106883

(35x)

50

8.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 MS27039-1-08

Screw

M106589

8/3/19

50

(30x)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut cable CBL-1240 in half (10.5" each) Remove 2.25" of sleeve from each end of cable CBL-1240

2-Crimp CBL-460 onto CBL-1240 to make (2) D2690-8 as per Dwg D2690. (Leave one end open)

3-Install Lanyard D2690-8 (from open end) into pin D2711 and assemble screw, washer and nut as per Dwg D206-651.

4-Install Lanyard D2690-8 into spring pin D2692 and assemble screw, washer and nut at other loop as per Dwg D206-651.

X30

m/08/03/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Pass 24 (30)

Comment: INSPECT WORK TO CURRENT STEP

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-651-041 CHG001

Location: *PKS*

PPP Rev: *A*

Packaging

DS 08/03/25 (30)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

DS 08/03/26

Job Completion



U 08/03/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

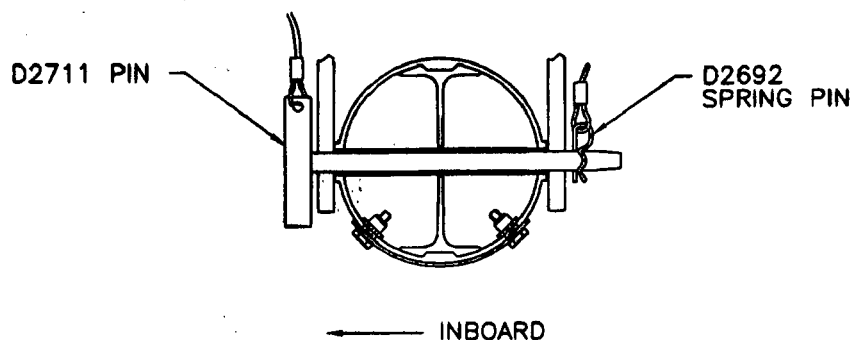
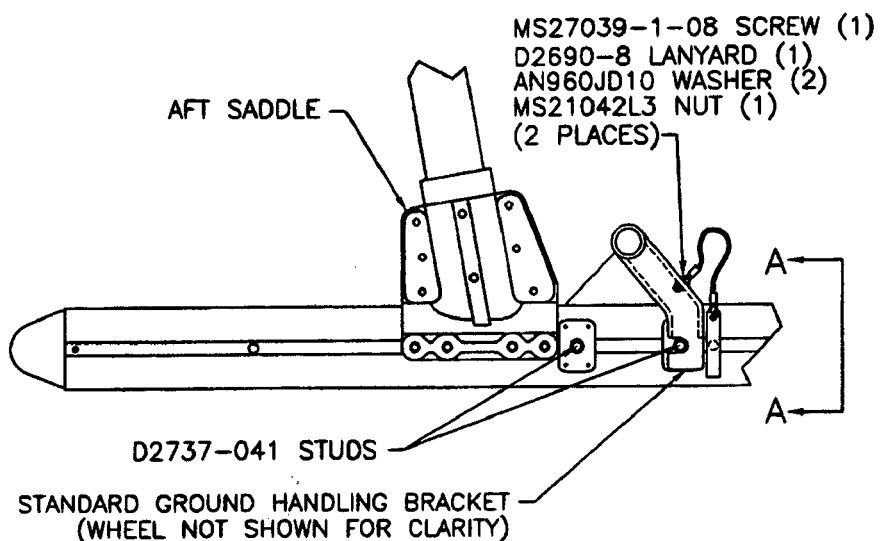
NOTE: Date & initial all entries

DART

DESIGN <i>DM</i>	DRAWN BY <i>DM</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>JS</i>	DRAWING NO. D206-651	REV. B SHEET 1 OF 1
DATE 98.01.27		TITLE GND. HANDLING WHEEL (GHW) INST.	SCALE NTS
A	97.11.03	NEW ISSUE	
B	98.01.27	D2688 REPLACED BY D2737-041	

TO ADAPT STANDARD BELL GROUND HANDLING WHEELS TO DART 206A/B SKIDTUBES:

1. ATTACH D2711 PIN AND D2692 SPRING PIN TO THE GROUND HANDLING BRACKET BY DRILLING $\phi 0.191$ HOLES IN THE FWD FACE OF THE BRACKET AND USING THE LANYARDS AND HARDWARE PROVIDED.
2. THE STANDARD BRACKET PICKS UP ON THE STUDS IN FRONT OF THE AFT SADDLE. SLIDE INTO PLACE AND INSTALL THE PIN SUPPLIED TO PREVENT THE UNIT FROM SLIPPING DURING GROUND HANDLING (SEE BELOW).
3. GROUND HANDLE IN THE NORMAL FASHION.
4. REMOVE THE BRACKET FOR FLIGHT. LEAVE THE PINS ATTACHED TO THE BRACKET.

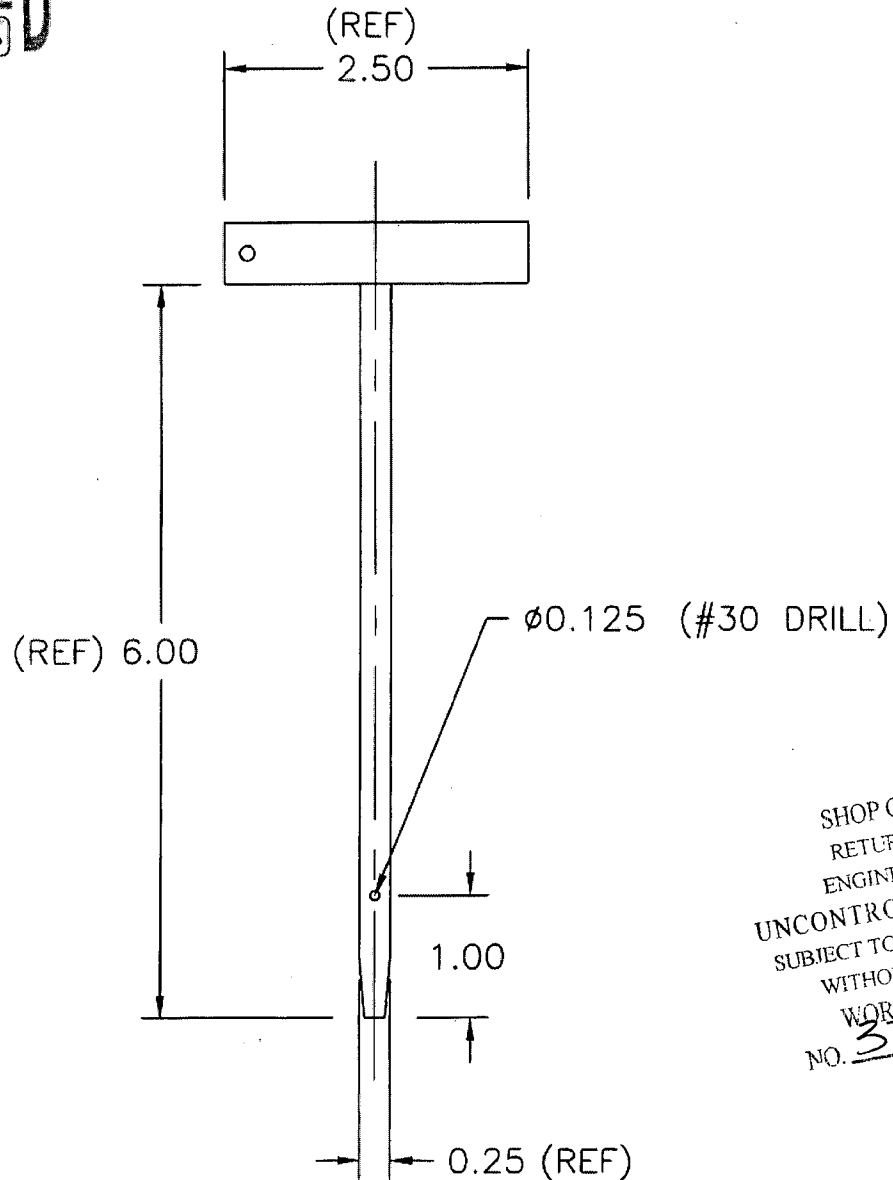


VIEW A-A



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2711	REV. A SHEET 1 OF 1
DATE 97.11.03		TITLE LOCK PIN	SCALE NTS
A	97.11.03	NEW ISSUE	

RELEASED
97/11/06 DS



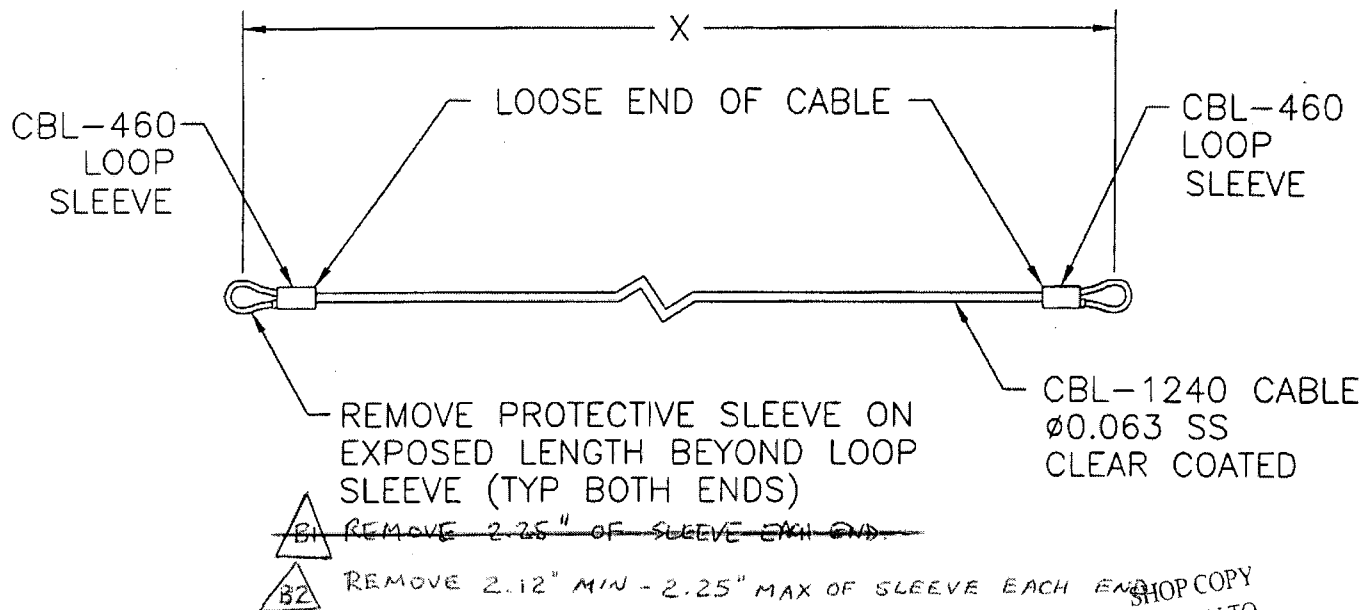
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37451

MAKE FROM REID TOOL SUPPLY PART # PNT-9
FINISH: CAD PLATE



DESIGN <i>ME</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>ME</i>	APPROVED <i>BW</i>	DRAWING NO. D2690	REV. B SHEET 1 OF 1
DATE 97.10.02		TITLE LANYARD ASSEMBLY	SCALE NTS
A	97.07.03	NEW ISSUE	
B	97.10.02	REVISED NOTE FOR ADDITIONAL LENGTH	
B1	CP 01.08.20	ADD NOTE TO REMOVE 2.25" OF SLEEVE	
B2	KE 04.06.24	ADDED TOLERANCE	

RELEASED
971003 KE
TSR A374



D2690-X

X = LENGTH IN INCHES

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37451

NOTE: CUT CABLE 2.50* INCHES LONGER THAN 'X' LENGTH.
FOLD ENDS TIGHT TO 'X' LENGTH AND CRIMP WITH
SLEEVE AT END OF LOOSE END OF CABLE WITH
CBL-705 CRIMPING TOOL.
*ADDITIONAL LENGTH MAY BE NECESSARY IN
SOME APPLICATIONS. CUT AS REQUIRED.

NOTE: IN SOME CASES, END HAS TO BE CRIMPED AFTER
ASSEMBLY WITH ATTACHING PARTS.